Work Order ID 94077

November-30-12 8:34:17 AM

94077

Item ID: D3876-3

Revision ID:

Item Name: Protector - Fwd Wall

Accept *N900040100*

Setup **Start** *NS1*

Stop *NS2*

Start Date: 11/27/12 **Start Qty:** 1.00 *1*

Required Date: 12/07/12 **Req'd Qty:** 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** MLJ **Date:** 12-12-03 **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run **Start** *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3876	**Revision Nbr** A								
100 *100* Waterjet FLOW CNC Waterjet	FLOW WATER JET **Memo** 1-Cut as per Dwg D3876Dwg Rev: A Prog Rev: A 2-Deburr if necessary	0.00 0.00				1			IB 12-12-16
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00				1			IB 12-12-16
120 *120* QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00 DAS 15 12 12 17				1			

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

	DISPOSITION	AGAINST DEPARTMENT/PROCESS
Work Order: ______ Part No. ______ NCR No. ______	Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 94077 *94077*

November-30-12 8:34:17 AM

Item ID: D3876-3 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Protector - Fwd Wall **Stop** *NS2*

Start Date: 11/27/12 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 12/07/12 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Identify as per dwg & Stock Location:______ Memo	0.00 0.00	PP 94045				12/12/12		DAS 20
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00					12/12/18		

12.12.18

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	______________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	______________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	______________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

November-30-12 8:34:17 AM

Work Order ID: 94077

Parent Item: D3876-3

Parent Item Name: Protector - Fwd Wall

Start Date: 11/27/12

Required Date: 12/07/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 09-01-14 new issue DD verifyed by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 GE PLASTICS LEXAN SHEET		Purchased	No			100	sf	704.2384	**3.86**	**4.0631579**	1B	12-12-16	

Location	Loc Qty	Loc Code
MAT018	704.2384	
121803	704.2384	

121803

(1)

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ________	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. ________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

DART AEROSPACE LTD	Work Order:	94077
Description: Protector – Fwd Wall	Part Number:	D3876-3
Inspection Dwg: D3876 Rev: A		Page 1 of 1

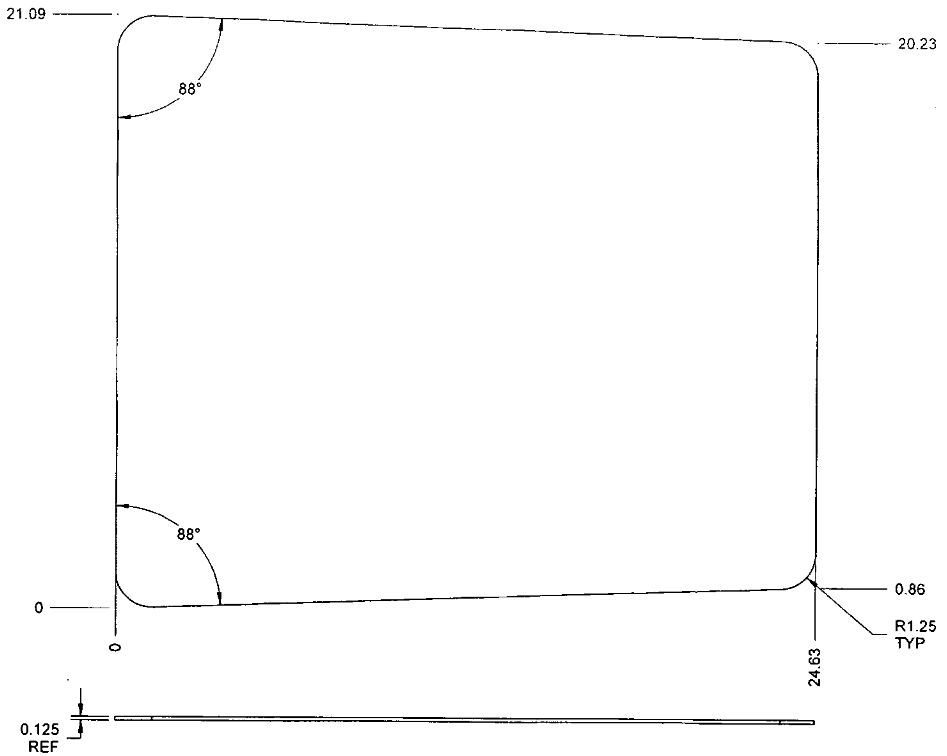
FIRST ARTICLE INSPECTION CHECKLIST

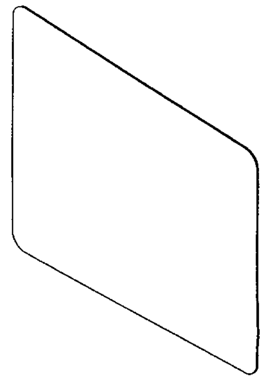
[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.43	+/-0.030	3.43	✓		T IB01	
11.05	+/-0.030	11.05	✓		T	
18.69	+/-0.030	18.69	✓		T	
25.86	+/-0.030	25.86	✓		T	
25.34	+/-0.030	25.34	✓		T	
21.86	+/-0.030	21.86	✓		T	
7.84	+/-0.030	7.84	✓		T	
5.40	+/-0.030	5.40	✓		T	
4.15	+/-0.030	4.15	✓		T	
0.35	+/-0.030	.35	✓		T IB01	
0.125	+/-0.010	.123	✓		V IB02	
1.84	+/-0.030	1.84	✓		T	

Measured by:	IB	Audited by:	QAS 15	Prototype Approval:	N/A
Date:	12-12-16	Date:	12 12 17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.22	New Issue	KJ [signature]	[signature]





D3876-1 PROTECTOR - RH FORWARD WALL
(TEXTURED SIDE SHOWN)

COPY
TO
CONTROLLED COPY
AMENDMENT
NOTICE
ORDER
94077_MLJ
12-12-03

RELEASED
09/06/03

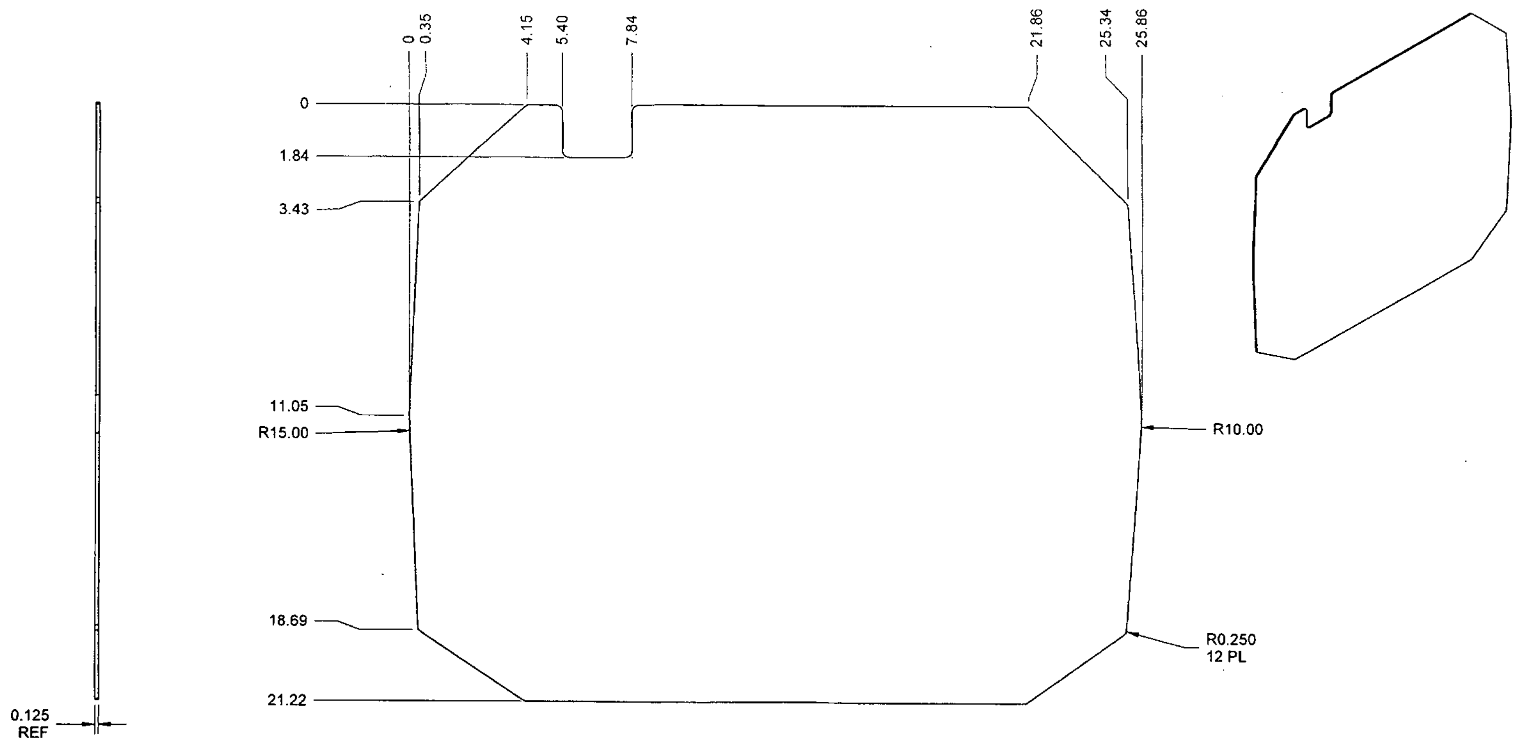
NOTES:
1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3876-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE
7) WEIGHT: 2.71 lbs
8) CHECK PER TEMPLATE DT8924

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	[signature]	09.04.02

DESIGN	[signature]	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	[signature]	
CHECKED	PH	DRAWING NO. D3876 — REV. A — SHEET 1 OF 7
MFG. APPR.	[signature]	
APPROVED	[signature]	TITLE BAGGAGE PROTECTOR — SCALE NTS
DE APPR.	[signature]	
DATE	09.04.02	

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94077



D3876-3 PROTECTOR - FORWARD WALL
(TEXTURED SIDE SHOWN)

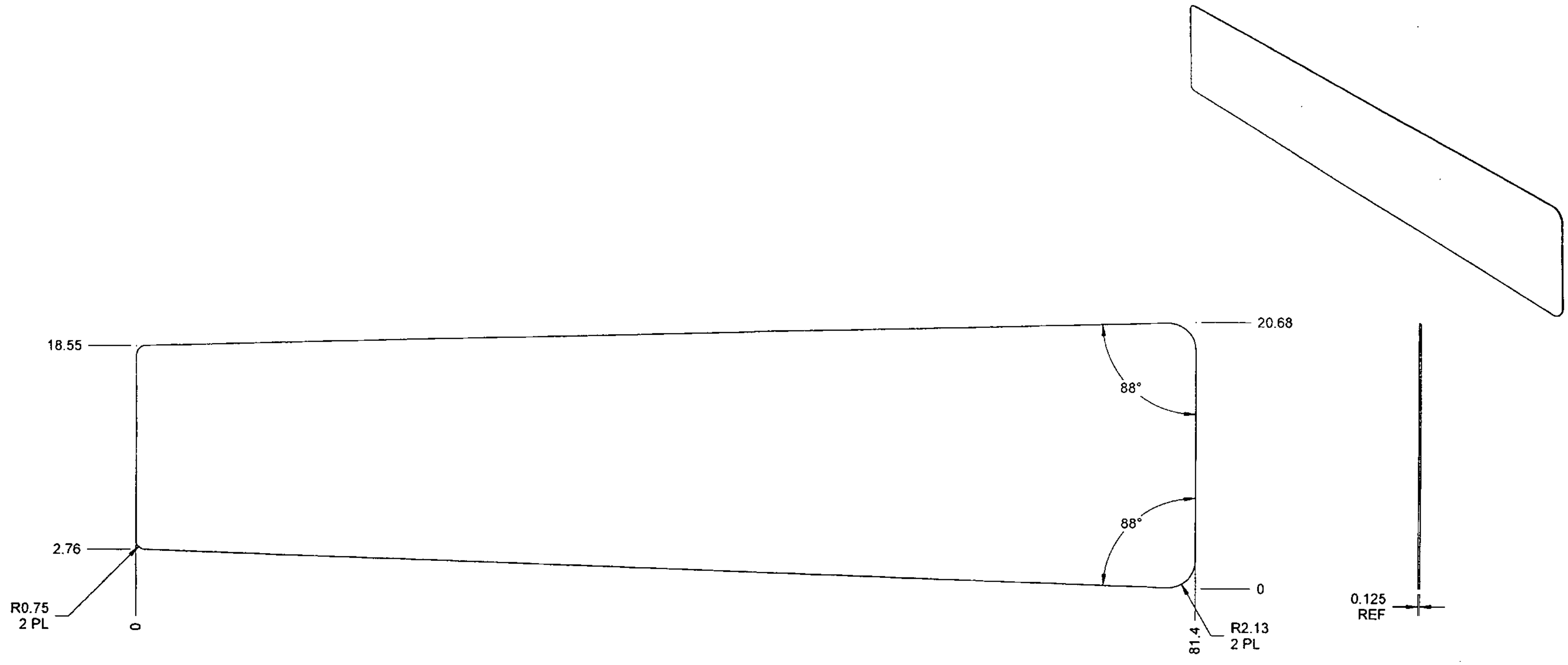
RELEASED

NOTES:
1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3876-3" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE
7) WEIGHT: 2.83 lbs
8) CHECK PER TEMPLATE DT8925

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D3876 REV. A SHEET 2 OF 7
CHECKED	PH	
MFG. APPR.		
APPROVED		TITLE BAGGAGE PROTECTOR SCALE NTS
DE APPR.		
DATE	09.04.02	

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D3876-5 PROTECTOR - LH WALL
(TEXTURED SIDE SHOWN)

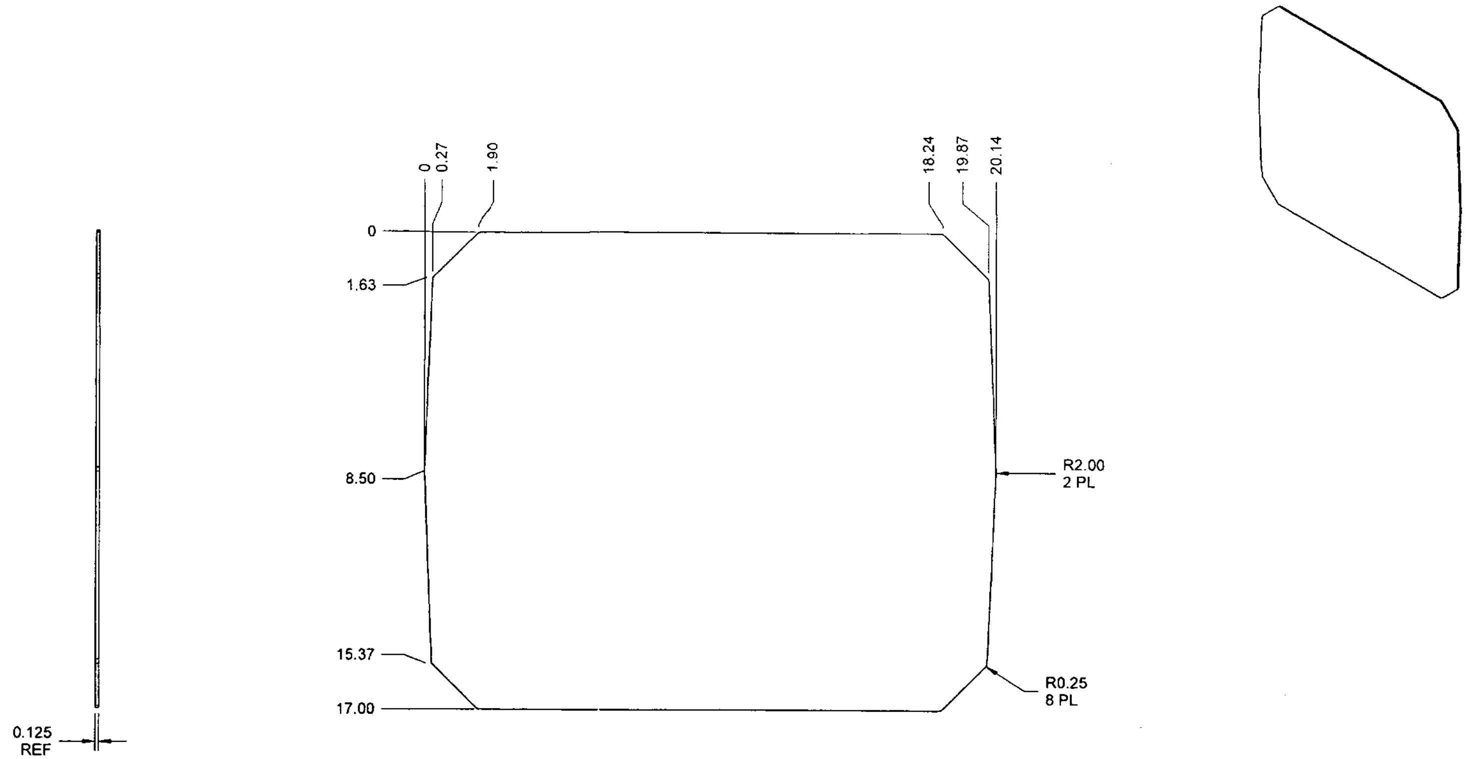
RELEASED 09/06/03

NOTES:
1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3876-5" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE
7) WEIGHT: 8.07 lbs
8) CHECK PER TEMPLATE DT8926

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D3876 — REV. A — SHEET 3 OF 7
CHECKED	PH	
MFG. APPR.		TITLE BAGGAGE PROTECTOR — SCALE NTS
APPROVED		
DE APPR.		
DATE	09.04.02	

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D3876-7 PROTECTOR - AFT WALL
(TEXTURED SIDE SHOWN)

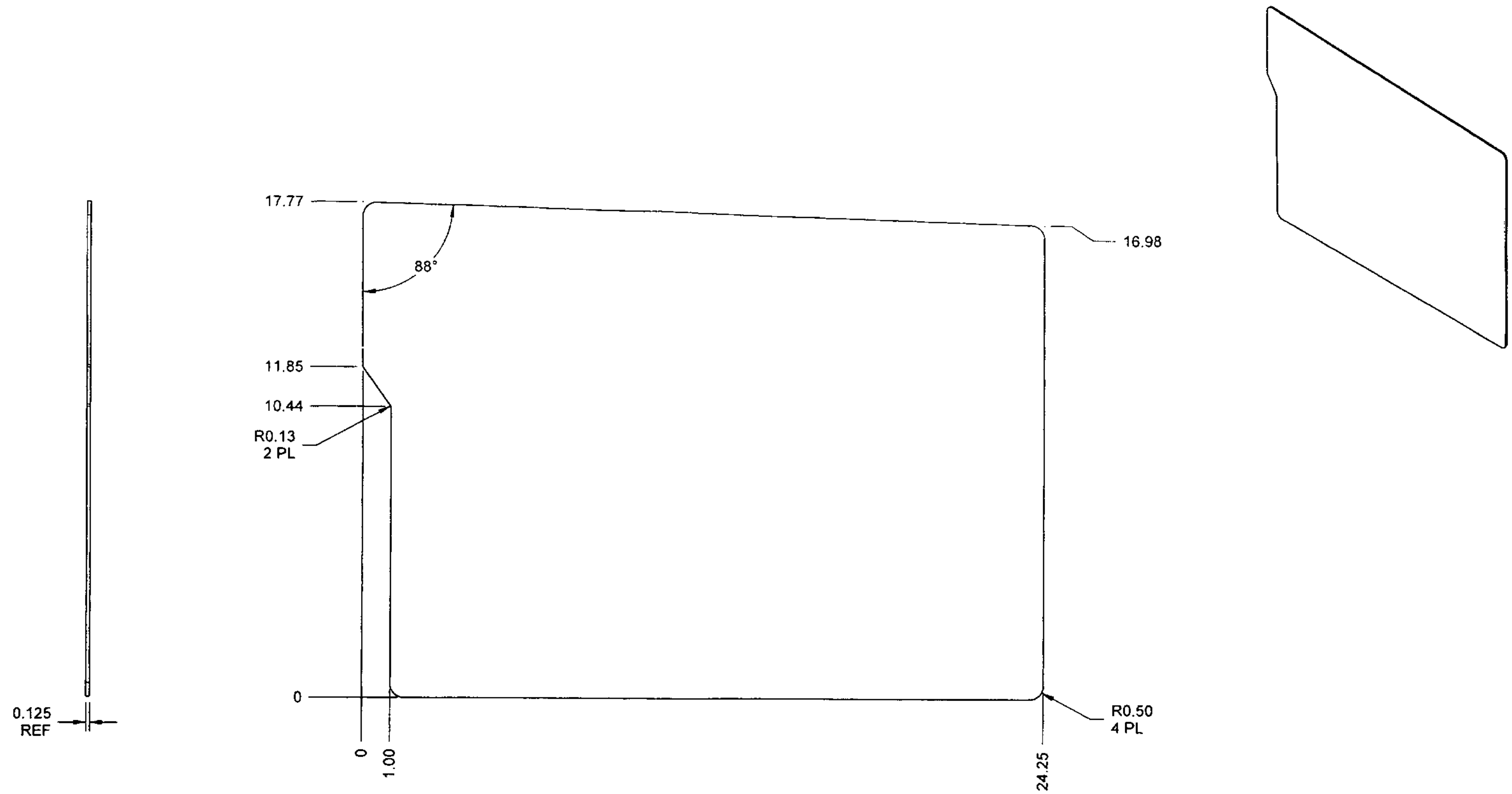
RELEASED 09/05/03

NOTES:
1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3876-7" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE
7) WEIGHT: 1.79 lbs
8) CHECK PER TEMPLATE DT8927

DESIGN	[signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	[signature]	
CHECKED	PH	DRAWING NO. D3876 — REV. A — SHEET 4 OF 7
MFG. APPR.	[signature]	
APPROVED	[signature]	TITLE BAGGAGE PROTECTOR — SCALE NTS
DE APPR.	[signature]	
DATE	09.04.02	

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D3876-9 PROTECTOR - RH AFT WALL
(TEXTURED SIDE SHOWN)

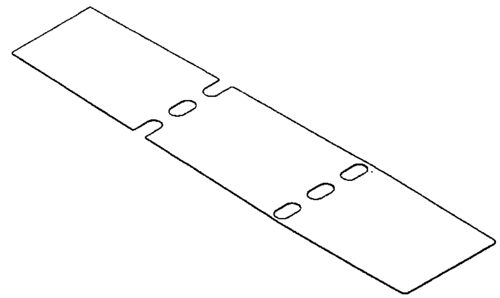
RELEASED 04/06/03

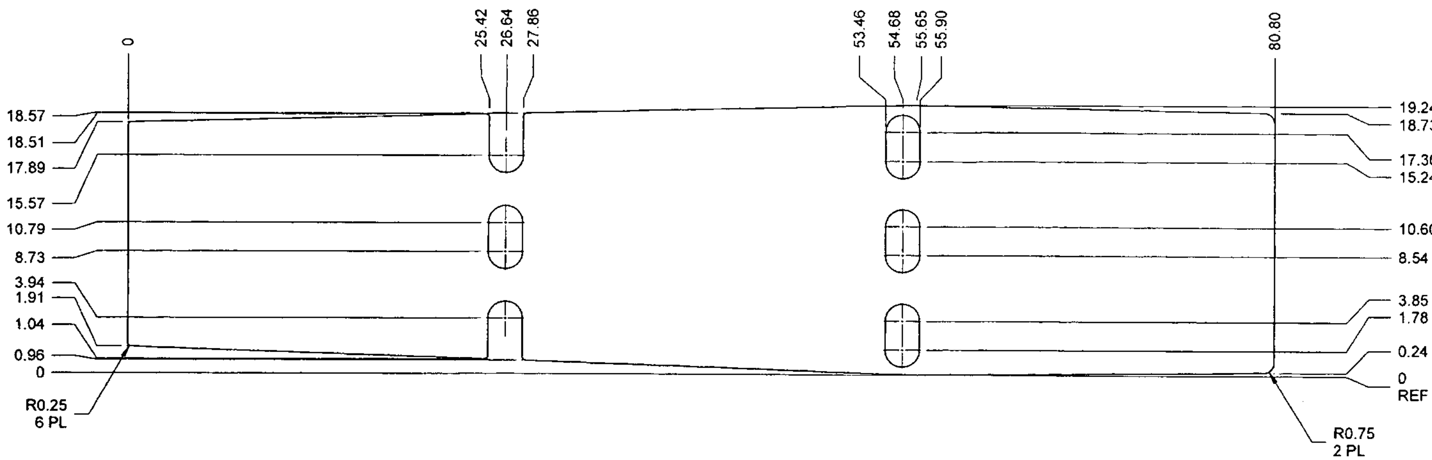
NOTES:
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REF DART SPEC MLEXS.125-F60029-04
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3876-9" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE
7) WEIGHT: 2.22 lbs
8) CHECK PER TEMPLATE DT8928

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D3876 REV. A SHEET 5 OF 7
CHECKED	PH	
MFG. APPR.		TITLE BAGGAGE PROTECTOR SCALE NTS
APPROVED		
DE APPR.		
DATE	09.04.02	

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D3876-11 PROTECTOR - FLOOR
(TEXTURED SIDE SHOWN)

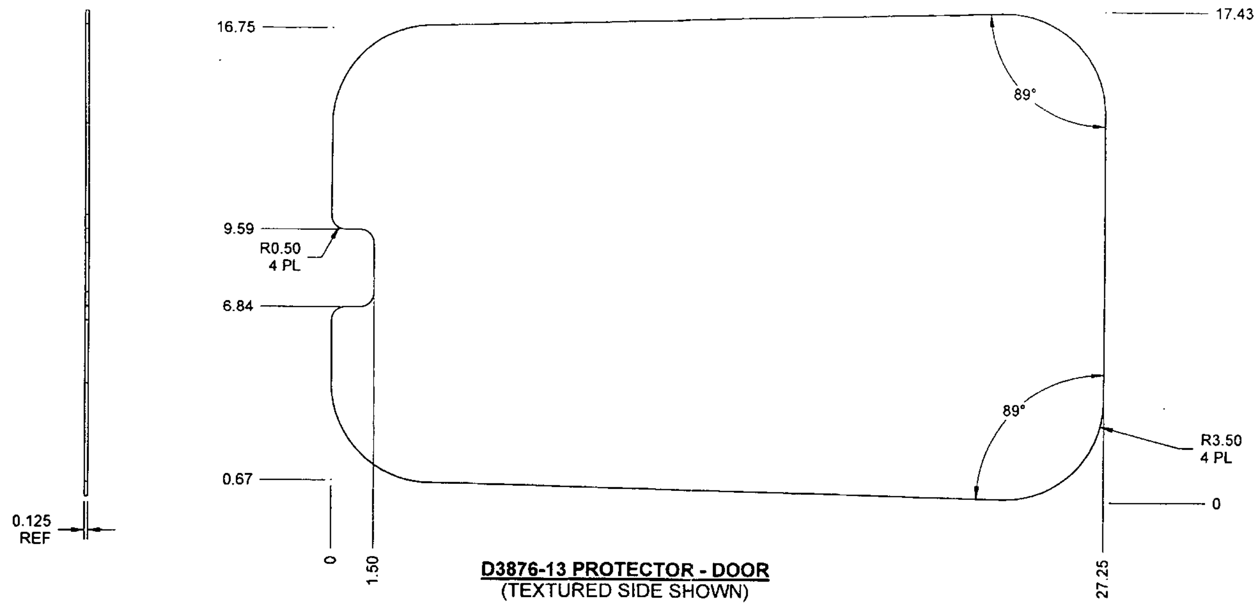
RELEASED 09/06/03

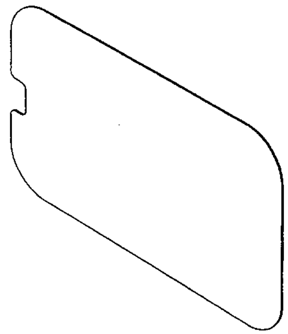
NOTES:
1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3876-11" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE
7) WEIGHT: 7.46 lbs
8) CHECK PER TEMPLATE DT8929

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED	PH	DRAWING NO. D3876 REV. A SHEET 6 OF 7
MFG. APPR.		
APPROVED		TITLE BAGGAGE PROTECTOR SCALE NTS
DE APPR.		
DATE	09.04.02	

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9407X





D3876-13 PROTECTOR - DOOR
(TEXTURED SIDE SHOWN)

RELEASED 9/06/03

NOTES:
1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3876-13" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE
7) WEIGHT: 2.41 lbs
8) CHECK PER TEMPLATE DT8930

DESIGN	[signature]	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	[signature]	
CHECKED	PH	DRAWING NO. D3876 — REV. A — SHEET 7 OF 7
MFG. APPR.	[signature]	
APPROVED	[signature]	TITLE BAGGAGE PROTECTOR — SCALE NTS
DE APPR.	[signature]	
DATE	09.04.02	

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